

Work Order ID 157986

Tuesday, March 07, 2017 8:10:12 AM

157986

Page 1

Item ID: D2364

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Deck Plate Fwd

Start Date: 3/8/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/10/2017 Req'd Qty: 4.00

4

Customer:

Reference:

MAR 07 2017

Approvals:

Process Plan:

DAS

21

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2364

Rev G

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.07

FLOW CNC Waterjet

1-Cut as per Dwg D2364

Dwg Rev: GProg Rev: G

2-Deburr if necessary

(4) 02/17/03/13

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

(4) 02/17/03/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Tuesday, March 07, 2017 8:10:12 AM

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[illegible]

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WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation			Disposition		
340 35 37 C			Completed By		
			Lead hand / Supervisor Approval Verification		
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150	HandFinish	0.05				<u>x4</u>	<u>0</u>		20170316 BEB
Hand Finishing	Memo								
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160	Powdercoat	0.03							4 0 1703-28. 3300
Powder Coating	Memo								
	START TIME: <u>9:00</u> OVEN TEMPERATURE: <u>300</u>								
	FINISH TIME: <u>9:30</u>								
170	QC3- Inspect Part Finish	0.00							
170	QC	0.01							DAS 38 9-89
Quality Control	Memo								4

MAR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 157986

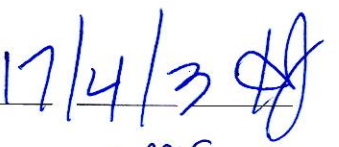
Tuesday, March 07, 2017 8:10:12 AM

157986

Page 4

Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate Fwd
Start Date: 3/8/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/10/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST225A</u> Memo	0.00 0.01				<u>4</u>			 MAR 30 2017
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							 MF 17-3-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
3411 18 95 E 10-00-04			Completed By		
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

Tuesday, March 07, 2017 8:10:16 AM

Page 1

Work Order ID: 157986

157986

Parent Item: D2364

D2364

Parent Item Name: Deck Plate Fwd

Start Date: 3/8/2017

Required Date: 3/10/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E00.06.26 Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	67.2500	0.6469	2.72379			

M2024T3S 063

2024-T3 .063 sheet

02/17/23/13

Location

Loc Qty

Loc Code

MAT

8.2

m135512

8.2

MAT009

59.05

m134640

32.9

m135612

20.75

n136492

5.4

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

DART AEROSPACE LTD		Work Order: 157986
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364 Rev: G		Page 1 of 1

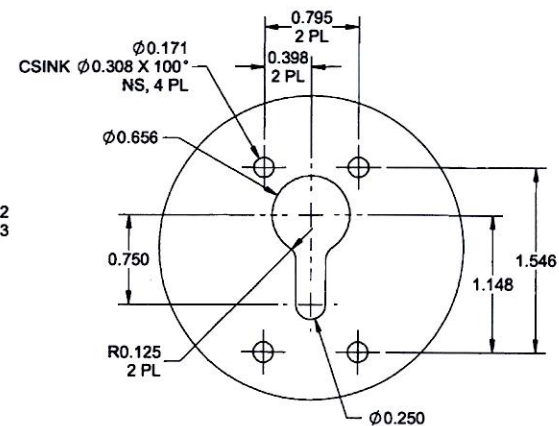
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.624	1		V: D-02	
Ø0.171	+0.005/-0.000	Ø.172	1		V: D-01	
0.354	+/-0.010	.354	1			
11.242	+/-0.010	11.244	1			
3.031	+/-0.010	3.032	1			
1.903	+/-0.010	1.904	1			
1.128	+/-0.010	1.130	1			
0.354	+/-0.010	.356	1			
1.340	+/-0.005	1.342	1			
2.326	+/-0.010	2.327	1			
3.312	+/-0.010	3.315	1			
4.298	+/-0.010	4.299	1			
5.284	+/-0.010	5.286	1			
6.151	+/-0.010	6.154	1			
6.270	+/-0.010	6.274	1			
0.354	+/-0.010	.355	1			
3.031	+/-0.010	3.032	1			
Ø0.656	+0.005/-0.000	Ø.655	1			
5.003	+/-0.010	5.003	1			
4.605	+/-0.010	4.606	1			
1.776	+/-0.010	1.779	1			
0.980	+/-0.010	.983	1			
4.487	+/-0.010	4.489	1			
7.192	+/-0.010	7.194	1			
7.567	+/-0.010	7.569	1			
7.942	+/-0.010	7.945	1			
Ø0.191	+0.005/-0.000	Ø.192	1			
Ø0.197	+0.005/-0.000	Ø.197	1			
11.145	+/-0.010	11.146	1			
12.181	+/-0.010	12.181	1			
11.776	+/-0.010	11.778	1			
0.250	+0.005/-0.000	.249	1			
3.141	+/-0.010	3.144	1			
0.171	+0.005/-0.000	.174	1			

Measured by: D	Checked by: DAS 38	QC Inspector:
Date: 17/03/16	Date: MAR 18 2017	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	
C	16.05.30	Dimensions revised per Dwg Rev G	KJ	



DETAIL A
SCALE 2X
2 PL

ATE
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WITHOUT NOTICE
WORK ORDER
NO. 157986 *Mu*

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2364" AND B/N "BXXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.42 lbs

G	REFORMAT DWG TO CURRENT STD. REVISE NOTE 1: THICKNESS WAS 0.063-0.071; REVISE NOTE 2: "BLACK SANDTENT" (4.3.5.7) WAS "BLACK CRINKLE" (4.3.5.3); ZN B4: 13.14 WAS 12.480. REASON: PAR15-415.	MB	15.10.28
F	0.063-0.071 THICK WAS 0.071 (TSR A371)	KE	98.06.19
E	GEOMETRY CHANGES	BW	95.10.06
D	0.191 WAS 0.197	BW	95.03.06
B	MOVED KEYWAY	BW	95.02.09
A	NEW ISSUE	BW	95.01.14
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2364 TITLE LITTER DECK PLATE, 350 COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DRAWN	MB		
CHECKED	AJS		
MFG. APPR.	JLM		
APPROVED	WM	REV. G	SHEET 1 OF 1
DE APPR.	DS	SCALE	NTS
DATE	15.10.28		